

**Amendments to the Claims:**

The following listing of claims will replace all prior versions, and listings, of claims in the application:

1. (Currently Amended) An ~~sheet-shaped insert bonded~~insert-molded cylindrical article ~~molded by insertion molding~~, comprising  
~~a cylindrical molded body having an inner surface, a mark of an injection gate opening positioned on said inner surface, and a barrel portion having an outer surface, and a sheet-shaped insert having an upper end;~~  
~~wherein and an~~said insert is bonded to ~~an~~said outer peripheral surface of ~~a~~said barrel portion of ~~the cylindrical molded body on molding, and~~  
~~wherein a~~said mark of ~~an~~the injection gate opening is positioned at ~~an~~said inner peripheral surface of the cylindrical molded body while being inwardly apart from ~~an~~said upper end of ~~the~~said insert in an axial direction and at a position corresponding to ~~a~~the position on ~~said~~said inner surface that is covered by ~~said insert~~an inner portion of ~~the~~the insert as viewed in width directions from opposite sides of ~~the~~the insert.

2. (Currently Amended) The ~~insertion-molded label-attached~~ cylindrical article set forth in claim 1, ~~further comprising a gap on said outer surface positioned between opposed ends of said insert and not covered by said insert,~~  
~~wherein the insert is bonded to a circumferentially entire outer peripheral surface of the cylindrical molded body, and the~~said mark of the injection gate opening is not located in ~~as~~the ~~position~~gap avoiding a butted portion of both side portions of the insert.

3. (Currently Amended) A method for ~~insertion molding~~making an ~~insert bonded~~insert-molded cylindrical article ~~by insertion molding with use of~~using an insertion injection molding mold,

said insertion-molded article comprising a cylindrical molded body having a molded body inner surface, a bottom portion, a barrel portion having an outer surface, and an insert having an upper end;

said insertion injection molding mold comprising an outer mold unit having an inner surface and a pull-out mold unit and defining a core-inserting space therein, and a core having and injection gate opening and shaped to be inserted and fitted into the outer molding unit, and a molding cavity defined between said outer mold unit and said core inside the injection molding mold,

-said method comprising-

fitting, closely attaching and holding an-said insert along an-said inner peripheral surface of the outer molding unit in a-said molding cavity defined between the outer mold unit and the core inside the injection molding mold,

-injecting a molten resin, through an-said injection gate opening provided in the core, toward an-said molded body inner peripheral surface of the molded body at a position inwardly apart from an-said upper end of the insert in an axial direction and at a position corresponding to an inner portion as viewed in width directions from opposite sides of the insert a position on said molded body inner surface that is covered by said insert, and

-curing and forming the cylindrical molded body while pushing the insert onto the inner peripheral surface of the outer molding unit with the molten resin,;

and thereby producing the insert-bonded cylindrical article comprising the molded body and the wherein said insert is integrally bonded to an-said outer peripheral surface of a-said barrel portion of the cylindrical molded body.

4. (Currently Amended) The molding-method set forth in claim 3, wherein said insertion-molded article further comprises a gap on said outer surface of said barrel portion positioned between opposed ends of said insert and not covered by said insert;

~~wherein the insert is fitted, closely-attached and held along a circumferentially-entiresaid inner peripheral surface of the cavity of the outer molding unitcavity, and~~

~~wherein the molten resin is not injected toward a position avoiding a butted portion of both side portions of the insertsaid gap.~~

5. (Currently Amended) The ~~molding~~ method set forth in claim 3, wherein a knock-out pin is provided in the core, ~~and whichsaid method~~ further comprising:

~~upwardly pulling out the pull-out mold unit of the outer mold unit after the insertion molding,~~

~~cutting a connection between the cured resin inside the injection gate opening and the cylindrical molded body by raising the knock-out pin, and~~

~~removing the cylindrical article from the core by pushing a the bottom portion of the cylindrical molded body.~~

6. (Currently Amended) The ~~molding~~ method set forth in claim 3, wherein the insert is fitted, closely-attached and held in a cylindrical shape along the inner peripheral surface of the outer mold unit in the molding cavity ~~by applying a contact frictional force between the core and the insertinside the injection molding mold, said contact frictional force formed~~ by partially fitting the insert in ~~a~~ the cylindrical shape into the outer mold unit ~~of the mold~~ in a state that the core of the injection molding mold is pulled out from the outer mold unit and the molding cavity is opened, forwardly moving the core into the outer mold unit, ~~and applying a contact frictional force between the core and the insert.~~

7. (Withdrawn) An apparatus for molding an insert-bonded cylindrical article comprising a cylindrical molded body and an insert integrally bonded to an outer peripheral surface of a barrel body of the cylindrical molded body, said apparatus comprising an outer mold unit having a cylindrical pull-out mold unit and defining a core-inserting space therein, a core to be inserted into the core-inserting space of the outer molding unit from one end thereof and to define a molding cavity between an inner peripheral surface of the core-molding space,

and a releasing tool for releasing the shaped insert-bonded cylindrical article from the mold, the outer molding unit comprising a barrel portion-molding mold unit having said core-inserting space and an end portion-molding mold unit to be engaged with the barrel portion-molding mold unit at the other end of the outer mold unit, having a molten resin-injecting opening and being capable of moving outside from an end portion, and the core having a gate hole communicating with the molten resin-injecting opening at one end, having the other end that is at the outer peripheral surface of the core and axially inwardly from the end portions of the insert fitted along the outer peripheral surface of the core-inserting space and at an inner portion of the insert located inwardly from both width sides of the insert.



8. (Withdrawn) The molding apparatus set forth in claim 7, wherein the insert-bonded cylindrical article has a mouth portion, and the end portion-molding mold unit comprises a molding mold end disc, as the pull-out mold unit, having a molten resin-injecting opening, and a mouth portion mold unit to be engaged with the mold end disc and form the mouth portion of the cylindrical article.

9. (Withdrawn) The molding apparatus set forth in claim 7, wherein radial molten resin runner grooves are formed at a joint face between one end of the core and the end portion-molding mold unit, and one end opening of the gate hole is to communicate with end portions of the running grooves.

10. (Withdrawn) The apparatus set forth in claim 7, wherein the outer mold comprising a stopper mold movable axially and adapted to form the other end of the cylindrical molded body, and the releasing tool is said stopper mold.

11. (Withdrawn) The apparatus set forth in claim 7, wherein the releasing tool further comprises a knock-out pin provided movably forwardly and rearwardly in a central portion of the core, and connection between the cured resin inside the injecting gate opening and the cylindrical molded body is cut by raising the knock-out pin.

12. (Currently Amended) The ~~molding~~-method set forth in claim 4, wherein a knock-out pin is provided in the core, ~~and which~~said method further comprising:

~~\_\_\_\_\_~~ upwardly pulling out the pull-out mold unit of the outer core mold unit after the injection molding,

~~\_\_\_\_\_~~ cutting a connection between the cured resin inside the injection gate opening and the cylindrical molded body by raising the knock-out pin, and

~~\_\_\_\_\_~~ removing the cylindrical article from the core by pushing ~~a~~the bottom portion of the gate cylindrical molded body.

13. (Currently Amended) The ~~molding~~-method set forth in claim 4, wherein the insert is fitted, ~~elosely~~-attached and held in a cylindrical shape along the inner ~~peripheral~~ surface of the outer mold unit in the molding cavity by applying a contact frictional force between the core and the insert inside the injection molding mold, said contact frictional force formed by partially fitting the insert in ~~a~~the cylindrical shape into the outer mold unit ~~of the mold~~ in a state that the core of the injection molding mold is pulled out from the outer mold unit and the molding cavity is opened, forwardly moving the core into the outer mold unit, ~~and applying a contact frictional force between the core and the insert.~~

14. (Currently Amended) The ~~molding~~-method set forth in claim 5, wherein the insert is fitted, ~~elosely~~-attached and held in a cylindrical shape along the inner ~~peripheral~~ surface of the outer mold unit in the molding cavity by applying a contact frictional force between the core and the insert inside the injection molding mold, said contact frictional force formed by partially fitting the insert in ~~a~~the cylindrical shape into the outer mold unit ~~of the mold~~ in a state that the core of the injection molding mold is pulled out from the outer mold unit and the molding cavity is opened, forwardly moving the core into the outer mold unit, ~~and applying a contact frictional force between the core and the insert.~~

15. (Withdrawn) The molding apparatus set forth in claim 8, wherein radial molten resin runner grooves are formed at a joint face between one end of the core and the end

portion-molding mold unit, and one end opening of the gate hole is to communicate with end portions of the running grooves.

16. (Withdrawn) The apparatus set forth in claim 8, wherein the outer mold comprising a stopper mold movable axially and adapted to form the other end of the cylindrical molded body, and the releasing tool is said stopper mold.

17. (Withdrawn) The apparatus set forth in claim 9, wherein the outer mold comprising a stopper mold movable axially and adapted to form the other end of the cylindrical molded body, and the releasing tool is said stopper mold.

18. (Withdrawn) The apparatus set forth in claim 8, wherein the releasing tool further comprises a knock-out pin provided movably forwardly and rearwardly in a central portion of the core, and connection between the cured resin inside the injection gate opening and the cylindrical molded body is cut by raising the knock-out pin.

19. (Withdrawn) The apparatus set forth in claim 9, wherein the releasing tool further comprises a knock-out pin provided movably forwardly and rearwardly in a central portion of the core, and connection between the cured resin inside the injection gate opening and the cylindrical molded body is cut by raising the knock-out pin.

20. (Withdrawn) The apparatus set forth in claim 10, wherein the releasing tool further comprises a knock-out pin provided movably forwardly and rearwardly in a central portion of the core, and connection between the cured resin inside the injection gate opening and the cylindrical molded body is cut by raising the knock-out pin.

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